

IN THE CLAIMS

1. (Currently Amended) Plate for producing housings and/or lids for button cell batteries, comprising:
 - a core layer of steel,
 - a copper or nickel clad top layer at one side of the core layer and
 - a nickel top layer at the other side of the core layer, ~~characterized in that~~ wherein the nickel top layer has been applied by depositing the nickel and ~~in that~~ wherein the core layer of steel has a thickness from 0.10 to 0.5 mm.
2. (Currently Amended) Plate according to claim 1, wherein the nickel layer has been applied by plating, ~~preferably electrolytic strip plating.~~
3. (Original) Plate according to claim 1, wherein the nickel layer has been applied by Physical Vapour Deposition (PVD) or by Chemical Vapour Deposition (CVD).
4. (Currently Amended) Plate according to claim 1, ~~2 or 3,~~ wherein the plate consists of a core layer of steel, a copper or nickel clad layer on one surface of the core layer and a deposited nickel layer on the other surface of the core layer.
5. (Currently Amended) Plate according to claim 1, ~~2 or 3,~~ wherein the plate consists of a core layer of steel, a deposited nickel layer on both surfaces of the core layer and a copper or nickel clad top layer on one of the nickel layers.
6. (Original) Plate according to claim 5, wherein the deposited nickel layer between the core layer of steel and the copper or nickel clad top layer is thinner than the deposited nickel top layer.

7. (Currently Amended) Plate according to ~~any one of the preceding claims~~ claim 1, wherein the core layer consists of mild steel, ~~preferably of deep drawing quality~~.

8. (Currently Amended) Plate according to ~~any one of the preceding claims~~ claim 1, wherein the plate has a thickness between 0.1 and 0.5 mm, ~~preferably between 0.1 and 0.2 mm~~.

9. (Currently Amended) Housing for a button cell battery fabricated from a plate according to ~~any one of the claims 1-8~~ claim 1.

10. (Currently Amended) Lid for a button cell battery fabricated from a plate according to ~~any one of the claims 1-8~~ claim 1.

11. (Currently Amended) Process for manufacturing of a plate according to ~~any one of the claims 1-8~~ claim 1, the process comprising the steps of:

- a providing step selected from the group consisting of:
 - (a) providing a hot rolled mild steel plate having a thickness between 0.7 and 5 mm~~[[,]] preferably 2.1 mm~~ and ~~[[-]] rolling the hot rolled mild steel plate to a thickness of preferably 1.0 mm; [[-]] or: [[-]]~~ (b) providing a cold rolled mild steel plate having a preferred thickness of 1.0 mm;
- depositing a nickel layer of 5 to 20 μm , ~~preferably 10 μm thick~~ on one side of the mild steel plate and optionally a nickel layer having a maximum thickness of 3 μm on the other side of the mild steel plate;
- cladding a copper or nickel layer of 1 to 20 %, ~~preferably 5 to 10 %~~, of the thickness of the steel plate on the other side of the steel plate;
- rolling and annealing of the steel plate to a thickness of 0.1 and 0.5 mm, ~~preferably 0.1 and 0.2 mm~~.

12. (Currently Amended) Process according to claim 11, wherein the mild steel plate ~~having a thickness of preferably 1.0 mm~~ is annealed before the nickel layer is deposited.

13. (Original) Process according to claim 11, wherein the mild steel plate with the deposited nickel layer is diffusion annealed after the nickel layer has been deposited.

14. (Currently Amended) Process according to claim 11, ~~12 or 13~~, wherein the mild steel plate is annealed before the plate is rolled to its final thickness of 0.1 to 0.5 mm, ~~preferably 0.1 to 0.2 mm~~.

15. (Currently Amended) Process according to ~~any one of claims 11-14~~ claim 11, wherein the nickel is deposited using Physical Vapour Deposition (PVD) or Chemical Vapour Deposition (CVD).

16. (Currently Amended) Process according to ~~any one of claims 11-14~~ claim 11, wherein the nickel is deposited by plating, ~~preferably electrolytic strip plating~~.

17. (New) Plate according to claim 2, wherein the nickel layer has been applied by electrolytic strip plating.

18. (New) Plate according to claim 7, wherein the core layer consists of mild steel of deep drawing quality.

19. (New) Plate according to claim 8, wherein the plate thickness is between 0.1 and 0.2 mm.

20. (New) Process according to claim 11, wherein the providing step is selected from the group consisting of (a) providing the hot rolled steel plate with a thickness of about 2.1 mm and cold rolled to a thickness of about 1.0 mm or (b) providing the cold rolled mild steel plate with a thickness of about 1.0 mm.

21. (New) Process according to claim 11, wherein the nickel layer deposited on one side of the mild steel is 5 to 10 μm thick and the nickel layer having a maximum thickness of 3 μm is deposited on the other side of the steel plate.

22. (New) Process according to claim 11, wherein the copper or nickel layer clad on the other side of the steel plate is 5 to 10 % of the thickness of the steel plate.

23. (New) Process according to claim 14, wherein the mild steel plate is annealed before the plate is rolled to its final thickness of 0.1 to 0.2 mm.

24. (New) Process according to claim 16, wherein the nickel is deposited by electrolytic strip plating.

25. (New) Process according to claim 11, wherein the providing step is selected from the group consisting of: (a) providing the hot rolled mild steel plate having the thickness between 2.1 and 5 mm and cold rolling the hot rolled mild steel plate; or (b) providing the cold rolled mild steel plate.

26. (New) Process according to claim 11, wherein the providing step is selected from the group consisting of: (a) providing the hot rolled mild steel plate having the thickness of 2.1 to 5 mm, pickling the hot rolled steel plate, and cold rolling the hot rolled mild steel plate; or (b) providing the cold rolled mild steel plate.

27. (New) Process according to claim 11, wherein the providing step is selected from the group consisting of: (a) providing the hot rolled mild steel plate of deep drawing quality having a thickness of 0.7 to 5 mm, which thickness is commercially available and pickling the hot rolled steel plate and cold rolling the steel plate to a thickness of approximately 1.0 mm; or

(b) providing a cold rolled mild steel plate in deep drawing quality having a thickness of approximately 1.0 mm.

28. (New) Process according to claim 11, wherein the copper or nickel layer clad on the other side of the steel plate is 5 to 10 % of the thickness of the steel plate; and the steel plate is rolled to a thickness of between 0.1 and 0.2 mm and annealed.